

Work Order ID 147552

Thursday, June 09, 2016 8:53:24 AM

147552

Page 1

Item ID: D3295-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacment Interior Window For -111
 Start Date: 6/2/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/8/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: PLS Date: **JUN 13 2016** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3295	E								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.05							
FLOW CNC Waterjet	***ENSURE PLASTIC BLOCK ARE ON TABLE BEFORE CUTTING PARTS***								
	1-Cut D3295-1 as per Dwg D3295								
	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Remove plastic, clean and wrap in saran wrap.								
	3-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									

PR 2016/07/25

4

4

PR 2016/07/25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
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Work Order update only ☐

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Work Order ID 147552

Thursday, June 09, 2016 8:53:24 AM

147552

Page 3

Item ID: D3295-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacment Interior Window For -111
Start Date: 6/2/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/8/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>STU36</u>	0.00				<u>4</u>	<u>PK</u>		<u>AUG 09 2016</u>
150									
Packaging	Memo	0.01							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.07							<u>16/8/9</u> <u>JA</u>
Quality Control									

ST AUG 09 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
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Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Picklist Print

Thursday, June 09, 2016 8:53:28 AM

Page 1

Work Order ID: 147552

147552

Parent Item: D3295-041

D3295-041

Parent Item Name: Replacment Interior Window For -111

Start Date: 6/2/2016

Required Date: 6/8/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1		Manufactured	Yes			140	Each	-5.0000	1	4			DAS 36 9-89
D2728-1									**			16/08/08	
Dart Logo Label Small													
MLEXS.125-9034-01		Purchased	No			100	sf	66.4890	1.24	5.221053			PR 2016/07/25
MI FXS 125-9034-01									**				
1/8" 9034 Lexan Sheet													

Location

Loc Qty

Loc Code

MAT019

66.489

125052

46.189

m134549

20.3

M135241

5.7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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DART AEROSPACE LTD		Work Order:	147552
Description: Window		Part Number:	D3295
Inspection Dwg: D3295 Rev: E		Page 1 of 1	

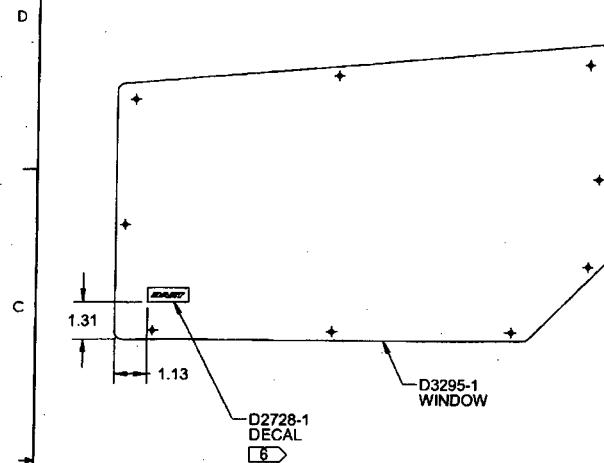
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	0.157	✓		Dec-02	
17.13	+/-0.030	17.13	✓		tape	
10.43	+/-0.030	10.43	✓		Dec-01	
14.35	+/-0.030	14.35	✓			
8.98	+/-0.030	9.00	✓			
0.625	+/-0.010	0.627	✓			
7.109	+/-0.010	7.110	✓			
15.845	+/-0.010	15.845	✓			
2.308	+/-0.010	2.308	✓			
5.420	+/-0.010	5.420	✓			
9.402	+/-0.010	9.402	✓			
1.312	+/-0.010	1.312	✓			
6.260	+/-0.010	6.262	✓			
12.520	+/-0.010	12.520	✓			
0.313	+/-0.010	0.318	✓			
3.750	+/-0.010	3.750	✓			
8.150	+/-0.010	8.150	✓			
9.006	+/-0.010	9.006	✓			
0.125	+/-0.010	0.123	✓			

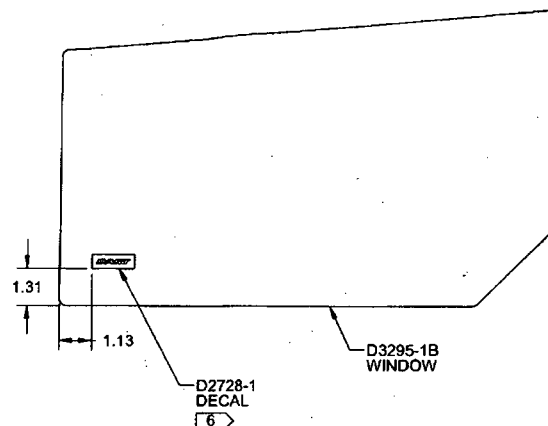
Measured by: PR / m	Audited by: DAS 38	Preliminary Approval:
Date: 2016/07/25	Date: JUL 26 2016	Date:

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	
B	13.02.27	Dwg Rev updated	KJ	

ITEM	QTY -041	QTY -041B	P/N	DESCRIPTION
	X		D3295-041	FLOOR WINDOW
		X	D3295-041B	FLOOR WINDOW, BLANK
1	1		D3295-1	WINDOW
2		1	D3295-1B	WINDOW, BLANK
3	1	1	D2728-1	DECAL



D3295-041 FLOOR WINDOW



D3295-041B FLOOR WINDOW, BLANK

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WITHOUT NOTICE
WORK ORDER

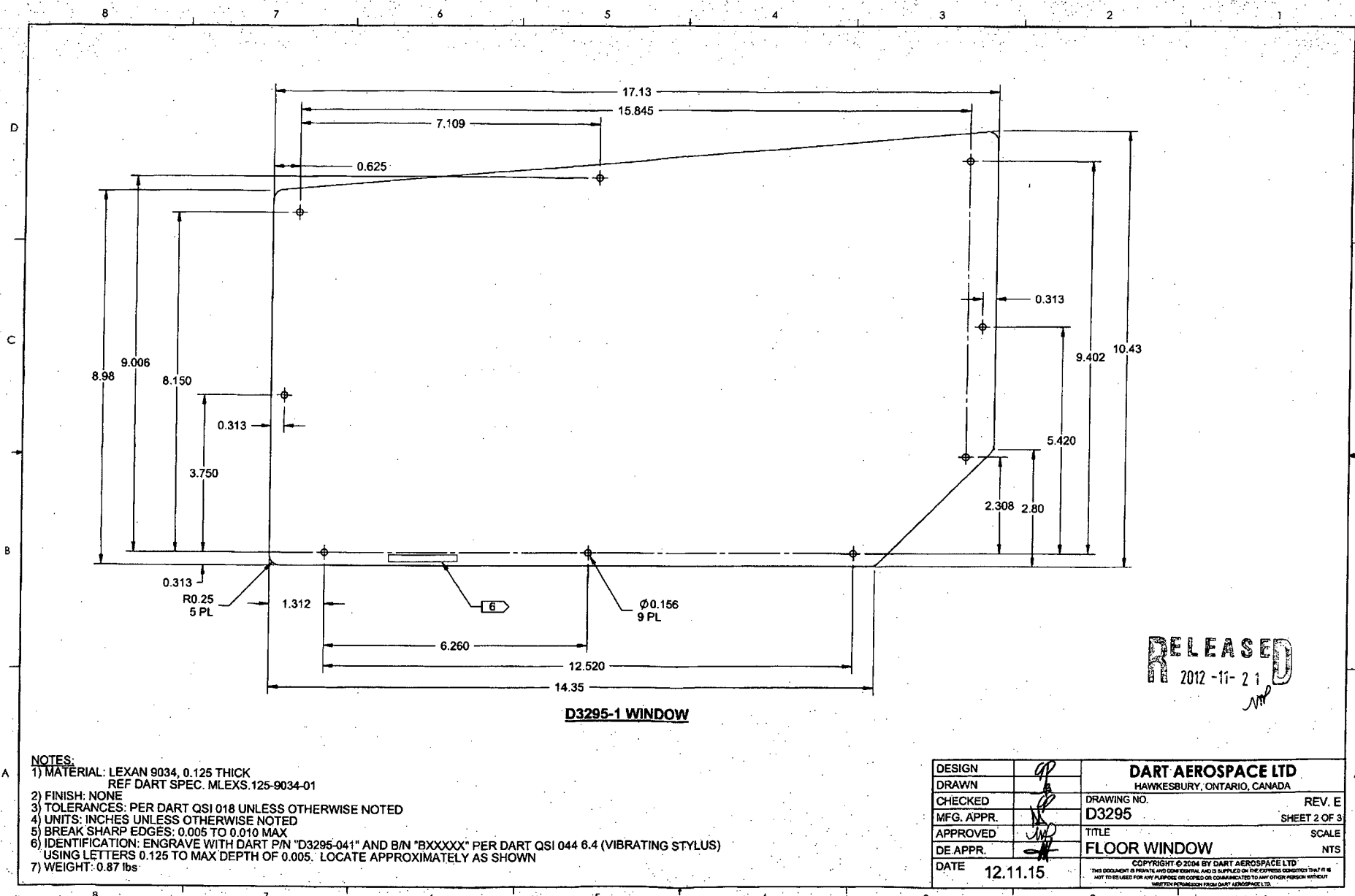
NO. 147552 MLS
1606-13

RELEASED
2012-11-21

REV.	DESCRIPTION	BY	DATE
E	ADD D3295-041B-1B. REF. PAR12-223.	MB	12.11.15
D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET. ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247. ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	08.04.13
A	NEW ISSUE	CP	04.08.28
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO.	REV. E
DRAWN		D3295	SHEET 1 OF 3
CHECKED		TITLE	SCALE
MFG. APPR.		FLOOR WINDOW	NTS
APPROVED			
DE APPR.			
DATE	12.11.15		

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) N/A
- 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
- 7) WEIGHT: D3295-041/-041B = 0.87 lbs



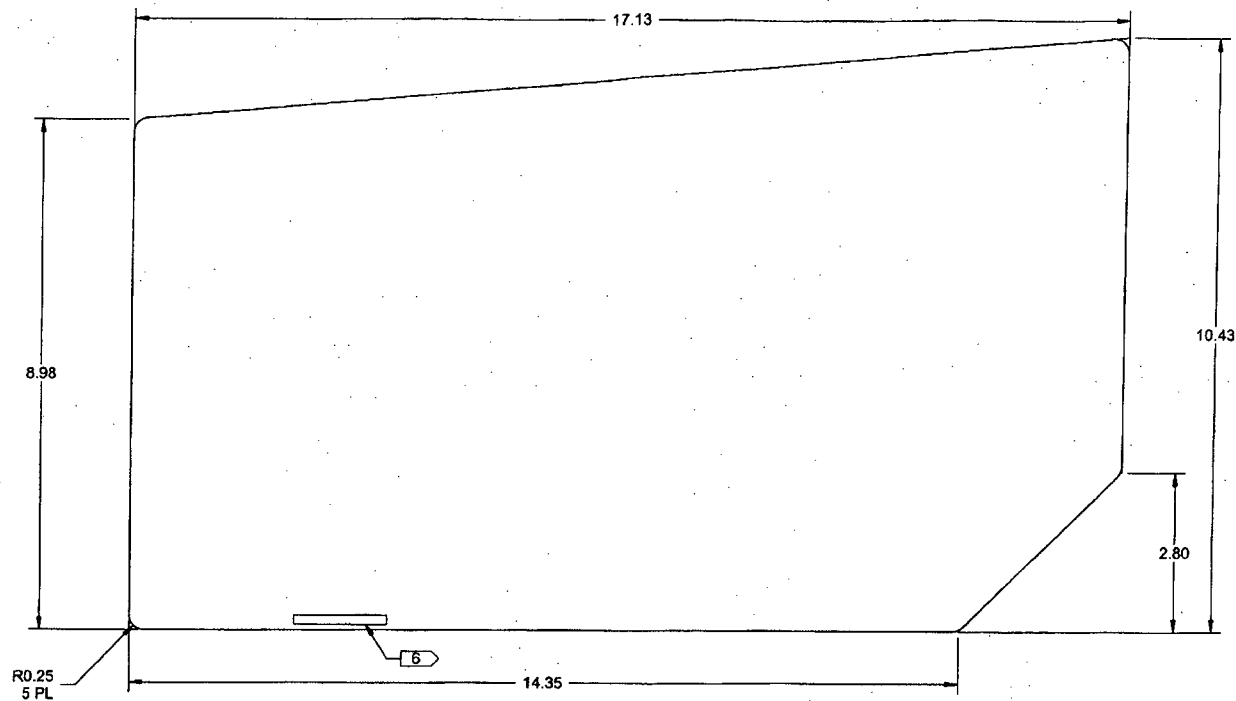
D3295-1 WINDOW

RELEASED
2012-11-21
MP

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3295	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW	NTS
DATE	12.11.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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D3295-1B WINDOW

RELEASED
2012-11-21
MP

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041B" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN.
- 7) WEIGHT: 0.87 lbs

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. E
MFG. APPR.	GP	D3295	SHEET 3 OF 3
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	FLOOR WINDOW	NTS
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